



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3371-1**Job Sheet 203840****Part No:** D3371-1**Job Qty:** 8 pcs**Part Name:** Pedal Lock Base**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 11/28/19**Job Tracking No:****Created By:** Jennifer Renwick**Due Date:** 1/30/20**Description:****Type:** Stock**Note:** DWG REV B IPP A 05.01.18 New issue KJ/JLM IPP RevB: add powdercoat DD 10.01.18 verified by:EC**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs		1/30/20	0.00	0.10	Bandsaw - 1		ALA 20/03/06
110	HAAS 4 Axis - B4B	8 pcs		1/30/20	0.20	10.13	HAAS - 1 - B4B		ALA 20/03/06
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	8 pcs		1/30/20	0.00	0.00	QC 2 - 1		KA 20-03-07
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		

**Container No:** S261610**Part:** D3371-1**Job No:** 203840**Serial No/Batch:** S261610**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 03/07/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 11/28/19 8:34 AM Dart.Renwick.Jennifer

130	QC 8	8 pcs	1/30/20	0.00	0.00	QC 2 - 63	
						QC 2 - 8	
						QC 2 - 66	
						QC 2 - 64	
						QC 2 - 65	
						QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
140	Handfinish - 1-1 Chemical- B4B	8 pcs	1/30/20	0.00	0.49	QC 8 - 8	B.E 20-04-28
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
						Handfinish - 1 - 1 - B4B	BEB 20-05-12
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 -	

https://www.plexonline.com/eb2e674a-49a1-4f1d-b2d3-f72f7d76c09b/Plexus_Control/Report_Viewer_2.asp?URL=https://www.plexonline.com/eb2e67... 3/4

					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170	QC 21 - SA	8	1/30/20	0.00	0.00	QC 21 - SA - 21
		pcs				QC 21 - SA - 70
						QC 21 - SA - 53

Part Op 100 - Cut blank: 2.00" x 2.25" x 7.370" long
 Descriptions: 110 - (HAAS CNC Vertical Machine), Machine D3371-1 as per Folio FA486 and Dwg D3371 Finish 8-32 thread by hand
 Identify as D3371-1
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 145 - (Fire Red(Ref:4.3.5.10) per QSI005 4.3), Heat oven at temperature for 45 minutes before putting part in oven
 by: _____
 150 - (QC3- Inspect Part Finish)
 160 - (Identify as per dwg & Stock Location: _____)
 170 - (QC21- Final Inspection - Work Order Release)

MAY 20 2020

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6S2.000X02.250	6061-T6 SHEET2.00 X 2.25	5 ft (.625 ea)	100-Bandsaw - 1	S234877 BX

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6S2.000X02.250	5	1	0

Part Specifications
Specifications could not be found.

DART AEROSPACE LTD		Work Order: 203840
Description: Pedal Lock Base		Part Number: D3371-1
Inspection Dwg: D3371	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
60°	+/-0.5°	60°	✓			
2.25	+/-0.030	2.253	✓		Kt-05	Verm.
1.650	+/-0.010	1.650	✓		" "	" "
1.648	+/-0.010	1.648	✓		31006	H-G
0.700	+/-0.010	0.700	✓		Kt-05	Verm.
3.955	+/-0.010	3.958	✓		" "	" "
0.600	+/-0.010	0.600	✓		CX-21	A+
0.104	+/-0.010	0.104	✓		Kt-05	Verm.
0.305	+/-0.010	0.305	✓		" "	" "
45°	+/-0.5°	45°	✓		CX-17	
0.672	+/-0.010	0.672	✓		Kt-05	Verm.
Ø1.300	+/-0.010	1.300	✓		" "	" "
1.450	+/-0.005	1.450	✓		Kt-05	Verm.
7°	+/-0.5°	7°	✓		CX-17	A-G
2.00	+/-0.030	2.001	✓		Kt-05	Verm.
1.125	+/-0.010	1.125	✓		" "	" "
Ø1.125	+/-0.010	1.129	✓		" "	" "
R0.500	+/-0.010	0.500	✓			A-G
1.000	+/-0.010	1.000	✓		Kt-05	Verm.
0.375	+/-0.010	0.377	✓		" "	" "
Ø0.203	+0.005/-0.000	0.206	✓		" "	" "
7.19	+/-0.030	7.185	✓		" "	" "
4.500	+/-0.010	4.495	✓		" "	" "
0.500	+/-0.010	0.495	✓		" "	" "

Measured by: KJ
Date: 20-03-07

Audited by: B.A
Date: 20-04-20

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Revised dimensions	KJ/JLM	

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QSI042)			
Description Work Order Deviation				Disposition							
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY							
				Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
				Other/Details: _____							
Completed By				Lead hand / Supervisor				QC / QA Coordinator			